

ASAP

Page 1

Work Order ID 58498

Friday, May 07, 2010 2:22:05 PM



Item ID: D3639-4

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 5/10/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: JMF

Date: 10-5-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3639	Rev A								

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo

0.00

B 10-5-10

(10)

I-Cut as per Dwg D3639 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

B 10-5-16

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

S 10-5-10

0.00

Pto →

(X) (S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3639-4 PAR #: Fault Category: Small Fails NCR: Yes No DQA: Date: 10/05/10
 Resolution: Disposition: QA: N/C Closed: Date: 10/05/10

NCR: 58498		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/10	#110	Founds QM + 5 parts with leads in / LEAD ends on different hubs. QC: process/water jet.	/	- Scrap + Destroy all + 4 no further extra made.	10-5-10	6 10/05/10	/	S 10/05/10

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Brake NC

Memo

Form as per Dwg D3639

88 1005 / 10

(5)

6

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. u. l o r k i o

(45)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

M 10/05/10

5 8

0.00

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Page 3

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Setup Start



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Start Date: 5/10/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

(5) 10-5-10

170



Packaging

Packaging

Identify as per dwg & Stock Location: 293

0.00

Memo

0.00

10-5-10 (5)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10-5-10 (5)
MF 10-5-10

W/O:		
DATE	STEP	

WORK ORDER CHANGES

PROCEDURE CHANGE

By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, May 07, 2010 2:22:04 PM

Page 1

Work Order ID: 58498



Parent Item: D3639-4



Parent Item Name: Doubler

Start Date: 5/10/2010

Required Date: 5/10/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	43.3947	0.4277	22	1.1	HB10-540

2024-T3 .050 sheet

Location	Loc Qty	Loc Code
MAT22	43.3947	
111381	32	111381
112291	11	
113189	0.3947	

~~111381~~ 10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	S8498
Description: Doubler	Part Number:	D3639-4
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.625	X			
Ø0.191	+0.005/-0.001	.192	X			
Ø0.098	+0.004/-0.001	.100	X			
0.45	+/-0.030	.447	V			
1.350	+/-0.010	1.350	V			
2.25	+/-0.030	2.251	V			
3.15	+/-0.030	3.151	V			
4.05	+/-0.030	4.055	X			
4.95	+/-0.030	4.950	X			
5.85	+/-0.030	5.848	X			
6.75	+/-0.030	6.755	V			
7.65	+/-0.030	7.659	V			
8.55	+/-0.030	8.553	X			
9.350	+/-0.010	9.354	V			
9.45	+/-0.030	9.451	V			
10.350	+/-0.010	10.351	V			
11.25	+/-0.030	11.255	V			
12.15	+/-0.030	12.15	V			
12.85	+/-0.030	12.85	→ RESEND			
13.86	+/-0.030	13.86	V			
13.96	+/-0.030	13.96	V			
0.805	+/-0.010	.810	V			
1.00	+/-0.030	1.002	V			
2.100	+/-0.010	2.100	V			
3.30	+/-0.030	3.307	V			
2.000	+/-0.010	2.000	X			
2.590	+/-0.010	2.592	V			

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	10-5-10	Date:	10/05/10	Date:	N/A

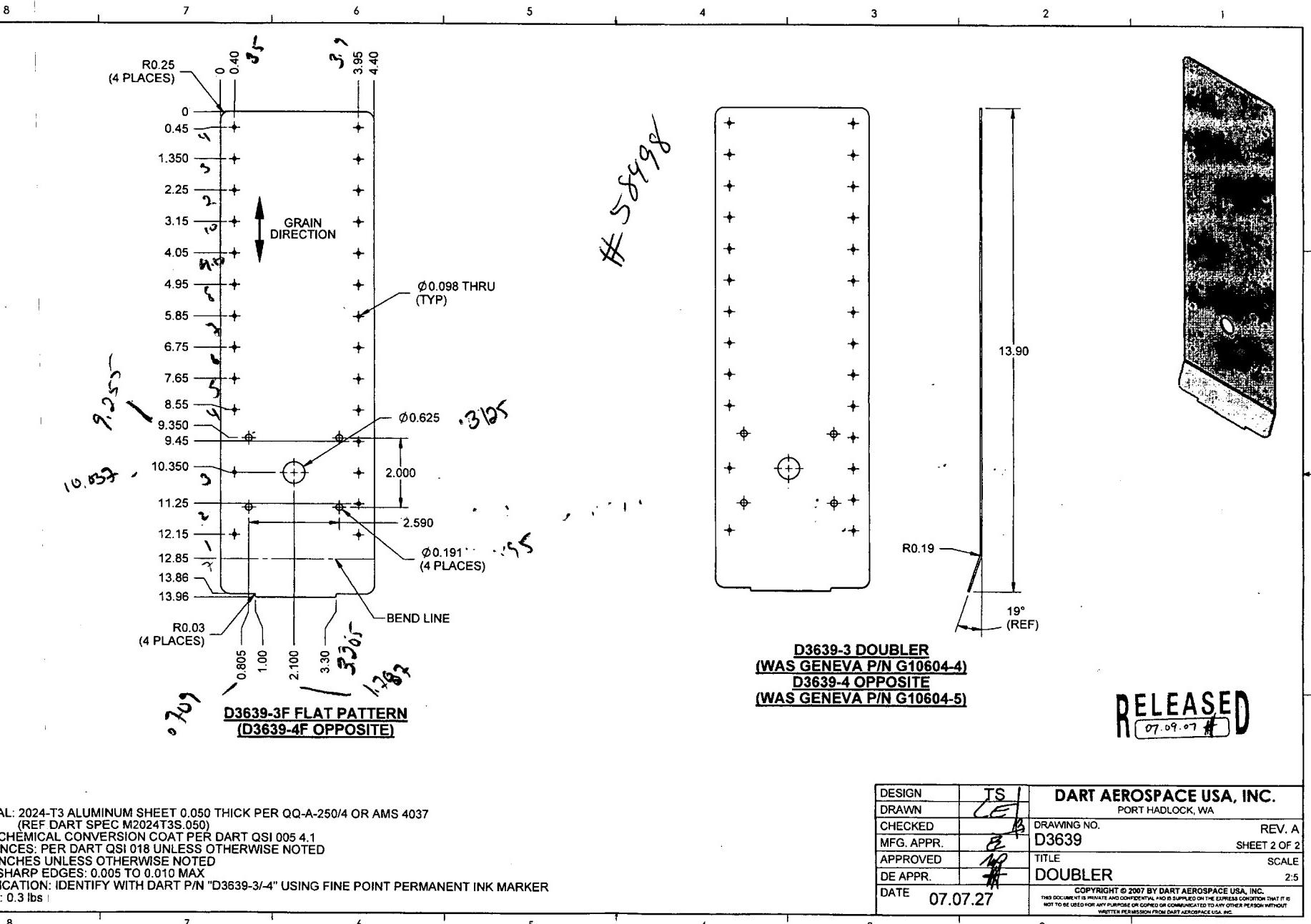
Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	BB

W/O:		WORK ORDER CHANGES					
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